

Date: Wednesday, 11/03/2009 1:06:36 PM
 User: Linda Lacelle

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46127
 Estimate Number : 10675
 P.O. Number :
 This Issue : 11/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 02/03/2009 Type : LARGE FAB ASSY
 Previous Run : 44485
 Written By :
 Checked & Approved By :
 Comment : EST REV. 05.11.17 NEW ISSUE EC

Drawing Name : STRUT WELDMENT ASSY
 Part Number : D3443041
 Drawing Number : D3443 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 13/03/2009 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34431 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-1	lug	B41913 → 7

SP 09.03.17

B46143 → 7

2.0 D34435 Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3443-5	Tubing	B46142

SP 09.03.17

3.0 D34531 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-1	Clevis	B42178

SP 09.03.17

4.0 238805 SS DOWEL PIN 3/4" LONG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-805	SS DOWEL PIN 3/4" LONG	M11689

Batch

M11689

SP 09/03/10 (X)

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3443

M 09/03/18 14X
SP 09-03-18 14X

6.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-18 (14)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/18 (14)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

2:00pm

OVEN TEMPERATURE:

400°C

FINISH TIME:

2:30pm

M 09-03-18 (14)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 09/03/20 (14)

10.0 63215K32 Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	63215K32	Spherical Bearing	

M 109340 x3

M 111039 x1

S 09/03/20 (14)

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

SP 09/03/20 (10)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46127

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0903-20

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 202 (suture)**09/03/20 x14*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
09/03/20

Job Completion

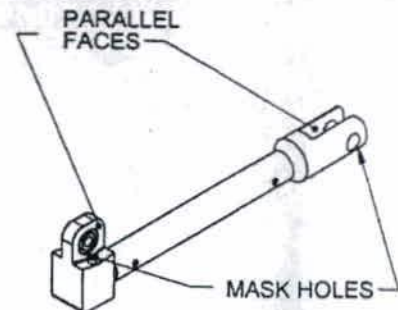
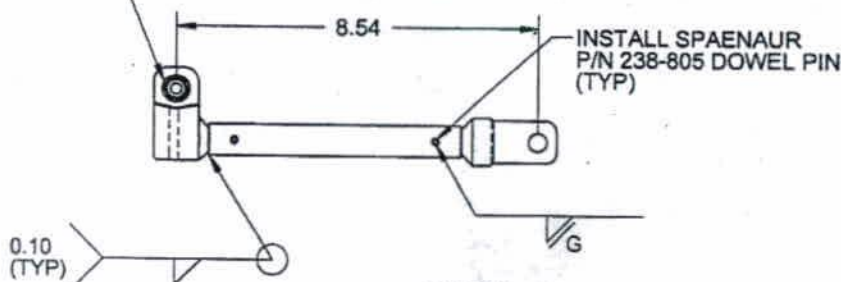
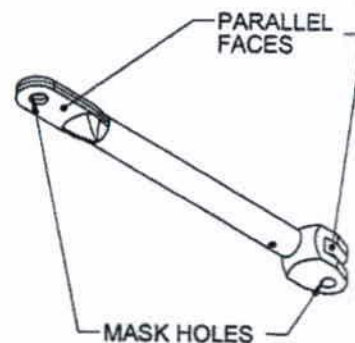
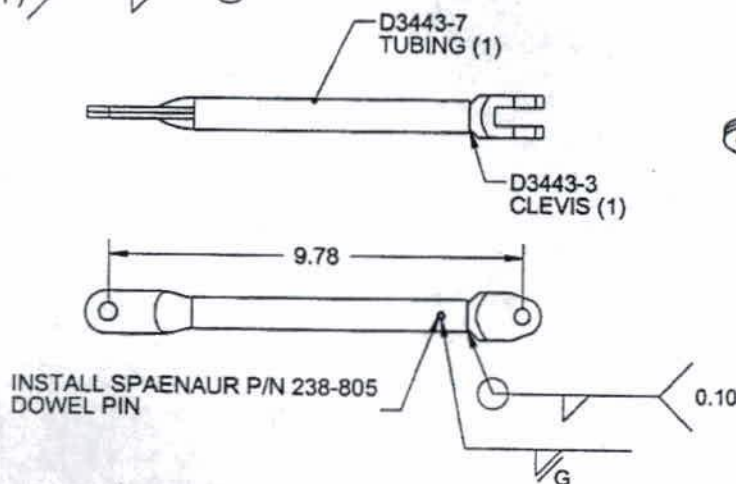
*09.03.20*

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø 0.125 WAS #30	

RELEASED05-12-09 *#*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****D3443-043** SHOP COPY

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO *10127*

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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